

Work Order ID 70457-1

Wednesday, June 08, 2011 7:39:31 PM



Page 1

Item ID: D2572

Accept



Setup Start



Revision ID:

Item Name: Saddle, Fwd In 205

Stop



Start Date: 6/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 12.00



Customer:

Reference:

Handwritten: 7.0, 11.06.08

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2572	Rev E

100

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. *70457*

Double check by:

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

SL 11/06/20

(F)

110

0.00



CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.00

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

SL 11/06/20

7

0

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Item ID: D2572

Accept

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Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/28/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC2- Inspect parts off machine FAI/FAIB

0.00

SL 11/06/20



QC

Memo

0.00

Quality Control

7

0

130

QC8- Inspect parts - second check

0.00

BA 11/06/20



QC

Memo

0.00

Quality Control

7

0

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

7 0 SL 11/06/20

Work Order ID 70457

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Item ID: D2572

Accept



Setup Start



Revision ID:

Stop



Item Name: Saddle, Fwd In 205

Start Date: 6/16/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 6/28/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00



Powdercoat

M116964

Memo

0.00

Powder Coating

START TIME:

10:35

OVEN TEMPERATURE:

320°

FINISH TIME:

*11:05**7**11-6-20*

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

*7**11-6-20*

170

Identify as per dwg & Stock Location:

433

0.00



Packaging

Memo

0.00

Packaging

11-6-20 ZSP

Work Order ID 70457

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Item ID: D2572

Accept

Revision ID:

Item Name: Saddle, Fwd In 205

Start Date: 6/16/2011 Start Qty: 12.00

Required Date: 6/28/2011 Req'd Qty: 12.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/6/21 [Signature]

ME
11-06-21

Picklist Print

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Page 1

Work Order ID: 70457

Parent Item: D2572

Parent Item Name: Saddle, Fwd In 205



Start Date: 6/16/2011

Required Date: 6/28/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP: ☐ 02.10.02 ☐ Re-format; Change to Dwg Rev. D & incorporated
D2572 ☐ KJ ☐

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6101-005 		Manufactured	No			100	Each	63.0000	1	12			
Saddle Billet													

Location

Loc Qty

Loc Code

MAT045

27

66966

27

MAT046

36

65382

11

65953

16

66966

9

21 11/06/20
7
5

DART AEROSPACE LTD		Work Order:	70457
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.501	.502	.502		
G	0.257	0.262		.257	.257	.257	.257		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.500	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.251	.251	.251	.251		
S	0.115	0.135		.127	.127	.127	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.241	.241	.241	.240		
W	0.115	0.135		.122	.122	.123	.120		
X	0.307	0.312		.310	.310	.309	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.363	.364	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.249	.250	.251	.248		
AE	1.375	1.395		1.387	1.386	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.270	.270	.270	.270		
AH	0.240	0.260		.250	.250	.250	.248		
AI	2.000	2.020		2.003	2.001	2.002	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	SL
Date:	11/06/15

Audited by:	KA
Date:	11/06/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD		Work Order: 70457
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	16	17	18		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.001	8.001	8.003		
F	0.490	0.510		.494	.498	.502	.498		
G	0.257	0.262		.259	.257	.257	.257		
H	0.375	0.380		.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.503	.501		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.566	.569	.569		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.875	3.874	3.874	3.874		
P	0.115	0.135		.127	.128	.128	.128		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.253	.253	.252		
S	0.115	0.135		.130	.128	.133	.132		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.960	2.960	2.960		
V	0.230	0.250		.241	.243	.244	.243		
W	0.115	0.135		.124	.130	.130	.129		
X	0.307	0.312		.310	.311	.310	.312		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.364	.363	.363	.366		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.624	.627	.626	.624		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.252	.252	.250		
AE	1.375	1.395		1.387	1.386	1.386	1.387		
AF	0.115	0.135		.135	.125	.125	.125		
AG	0.240	0.280		.250	.260	.260	.260		
AH	0.240	0.260		.250	.253	.252	.252		
AI	2.000	2.020		2.005	2.005	2.005	2.008		
AJ	0.023	0.043		.033	.035	.035	.035		
Accept/Reject									

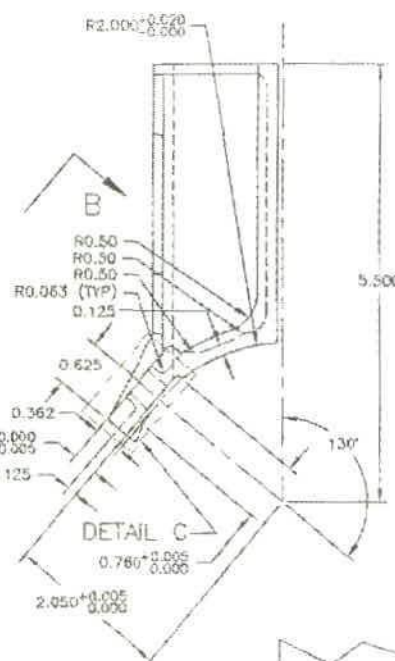
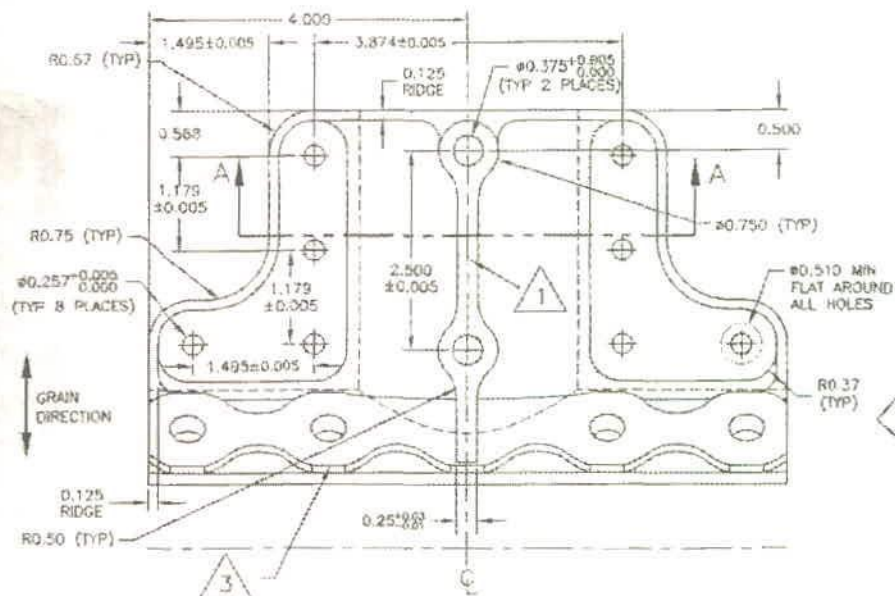
Measured by:	St
Date:	11/06/20

Audited by:	D.A
Date:	11/06/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
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D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

RELEASED

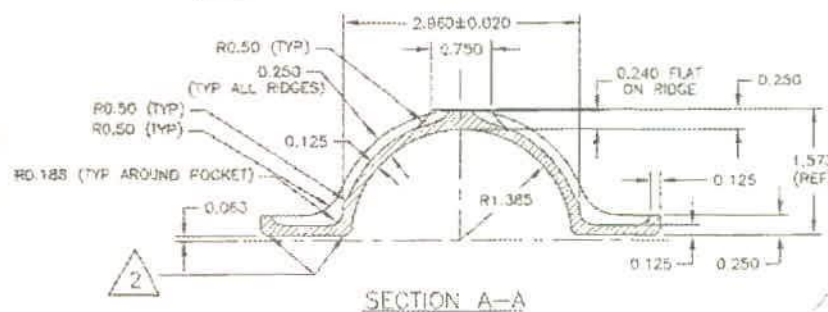
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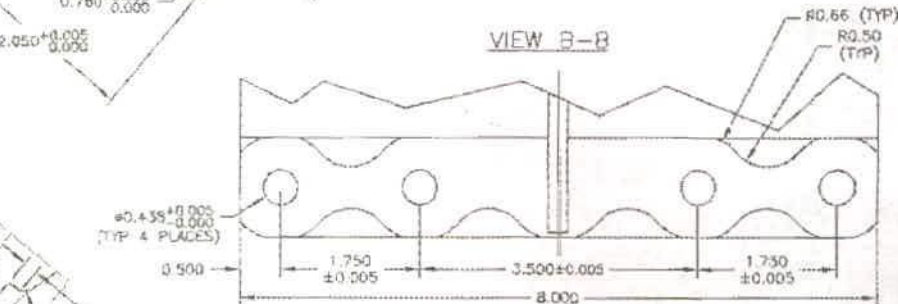
NOTES

MATERIAL: 7075-T7351 (Q0-A-250/12)
 REF DART SPEC D6102-003
 FINISH: ACID ETCH, ALDINE PER DART QSI 005 4:1
 POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
 DART QSI 005 4:3
 BREAK ALL SHARP EDGES 0.010 TO 0.020
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
 3 CHAMFER 0.063 x 45° ALL AROUND
 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E



SECTION A-A

DETAIL C
SCALE 2:1

VIEW B-B

E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEC 9123/9078/9102 ADD DIMENSIONS PER TSR A1177
B	98.12.02	ADD GRAIN DIR. 0.438 WAS C-425
A	96.09.16	NEW ISSUE
DESIGN	DS	DRAWN BY PH
CHECKED	#	APPROVED #
DATE	05.07.13	DRAWING NO. D2572
		TITLE INNER FWD SADDLE
		REV. 1 SHEET 1 OF 1 SCALE 2:1

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